

Shp April 12

Work Order ID 81571

81571

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March-15-12 1:00:48 PM

Item ID: D3826-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Rib / Gusset Assembly
 Start Date: 15/03/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 13/04/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MJS Date: 12/03/15 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3826	Rev B

100	Large Fab	0.00
100		
Large Fab	Memo	0.00
Large Fab	1- assemble D2325 support gusset together	
	2- locate D2325 on rib and weld as per dwg D3826	
	A/R ER316 S.S. Rod Batch: M118161	

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
110		
QC	Memo	0.00
Quality Control		

120	QC5- Inspect part completeness to step on W/O	0.00
120		
QC	Memo	0.00
Quality Control		

12.06.21 (4X)

CC 12.6.21 (4X)

Pl 12.06.22

Shp 12.06.22

Pl 12.06.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/0/27 9A
MF
12-06-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

March-15-12 1:00:52 PM

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Work Order ID: 81571

81571

Parent Item: D3826-041

D3826-041

Parent Item Name: Rib / Gusset Assembly

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2235-1		Manufactured	No			100	Each	19.0000	1	4			
D2235-1													
Basket Rib													

**

B 82951 → 4x *SD* 12.06.14
B 86051 → 4x

Location	Loc Qty	Loc Code
WA	5	
78636	5	
WA005	14	
66895	4	
79153	10	

D3929-041

Manufactured No

100 Each 10.0000

1

4

D3929-041

Gusset Assembly

**

SD 12.06.14

Location	Loc Qty	Loc Code
WA005	10	
77675	2	
79152	8	

B 85715 → 3x

1x
3x + 1x

D3929-042

Manufactured No

100 Each 12.0000

1

4

D3929-042

Gusset Assembly

**

SD 12.06.14

Location	Loc Qty	Loc Code
WA005	12	
77675	4	
79154	8	

1x
3x + 4x

B 85716 → 1x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

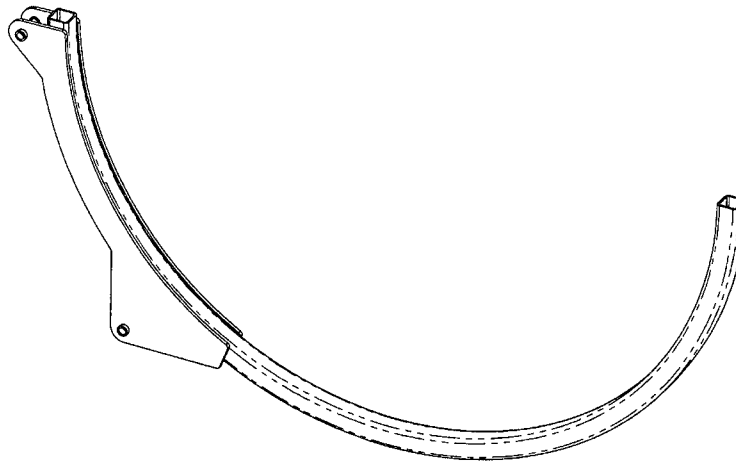
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ITEM	QTY. .041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81571 MCT
12/03/15



D3826-041 RIB/GUSSET ASSY

RELEASED
9/16/12

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 3.32 lbs

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	16		
DRAWN	16		
CHECKED	16		
MFG. APPR.	16		
APPROVED	16		
DE APPR.	16		
DATE	09.04.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3826** REV. B
SHEET 1 OF 2
TITLE **RIB/GUSSET ASSY** SCALE NTS

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△ B D3929-042
GUSSET ASSEMBLY

△ B D3929-041
GUSSET ASSEMBLY

TYP

0.250

D2235-1
RIB

D3826-041 RIB/GUSSET ASSY

RELEASED
9/24/22-140

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
DATE	09.04.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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